

Monday, 6/19/2006 11:25:56 AM

User: Kim Johnston.

## Process Sheet

Customer	: CU-DAR001, Dart Helicopters Services	Drawing Name	: STA 155 BRACKET
Job Number	: 27615		
Estimate Number	: 11039		
P.O. Number	: N/A	Part Number	: D28041
This Issue	: 6/19/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2804 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27112	Drawing Revision	: B
		Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 7/10/2006
Checked & Approved By	: <u>06.06.19</u>	Qty:	20
Comment	: Est. A00.11.06 New Issue EC	Um:	Each
	: Est. B06.05.30 Blanks on wtjetEC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
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Comment: Qty.: 0.7875 f(s)/Unit Total: 15.7500 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M10120306.06.22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: BProg Rev: B

2-Deburr if necessary

06/06/23(20)SAD06.06.22(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

J.F. ml06/06/2219(19)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/2219


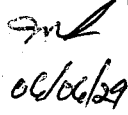
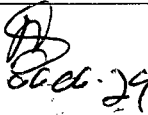

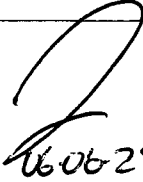
5.0	QC8	SECOND CHECK
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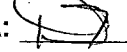


Comment: SECOND CHECK

J.L. 06/06/22(19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/29	3	1 part scrap. Deep surface Damage on the mat'l. from storage, or handling other mat'l, And hitting it.		Scrap - destroy. No Replace.	 06/06/29	 06/06/29		 06/06/29

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/06

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:25:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 27615

Part Number: D28041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble & Deburr

*in 06/06/29 19*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*in 06/06/29 19*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*SAH 06207.04 19*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *ST156*

*26/7/5 (19)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*26/07/06 (19)*

Job Completion



*U. 26.07.05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 27615
<b>Description:</b> Bracket		<b>Part Number:</b> D2804-1
<b>Inspection Dwg:</b> D2804	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.010/-0.001	Ø.759"				
Ø0.191	+0.005/-0.001	Ø.191"				
1.420	+/-0.001	1.421"				
Ø0.507	+0.000/-0.001	Ø.507"				
0.250 deep	+/-0.010	.254"				
Ø0.507	+0.000/-0.001	Ø.507"				
Ø0.191	+0.005/-0.000	Ø.191"				
6.933	+/-0.010	6.933"				
7.578	+/-0.010	7.578"				
12.304	+/-0.010	12.304"				
0.125	+/-0.010	.125"				
0.500	+/-0.010	.497"				
0.125	+/-0.010	.130"				
0.250	+/-0.010	.249"				
0.875	+0.000/-0.001	.875"				
0.250	+0.000/-0.005	.248"				

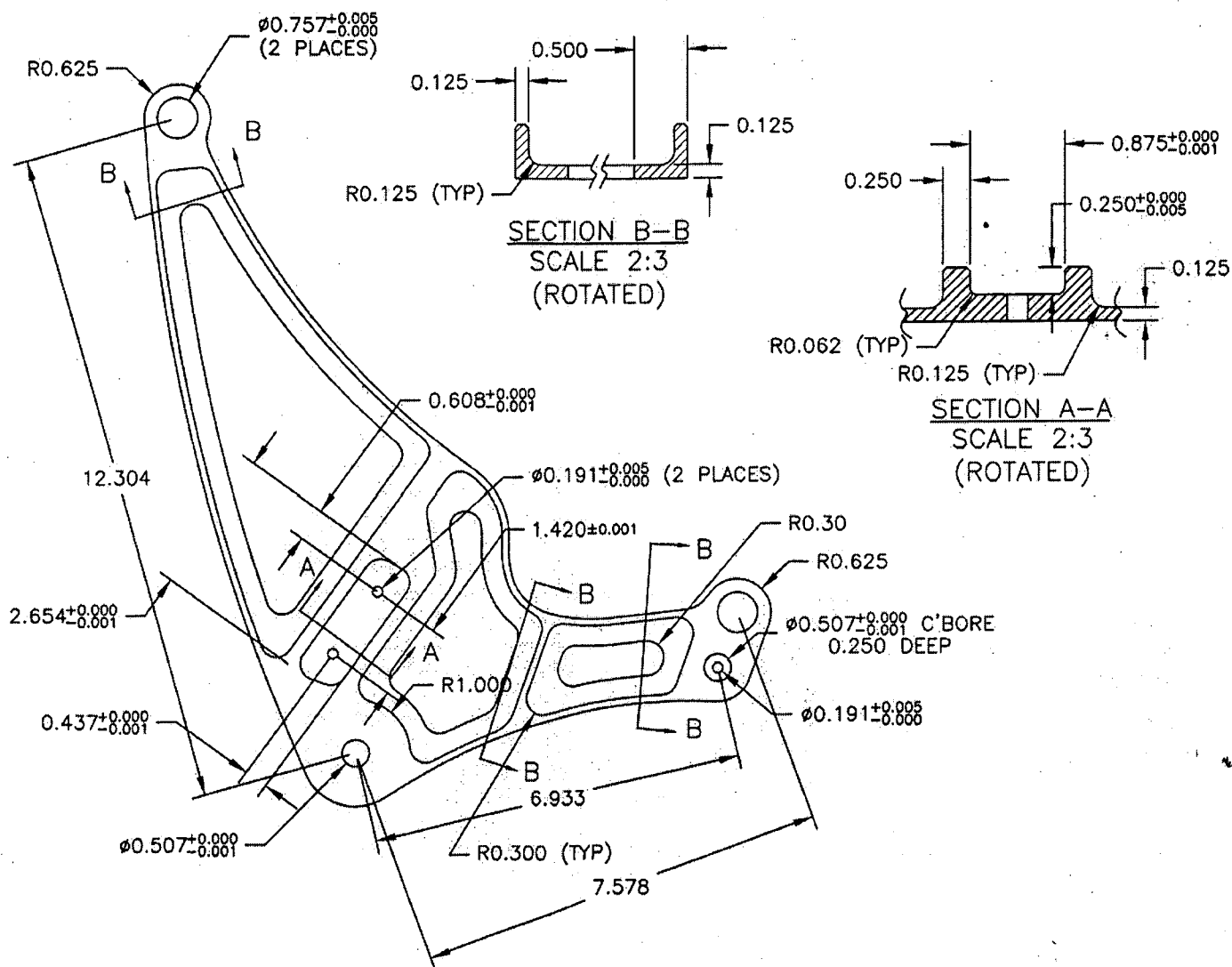
<b>Measured by:</b> J.F.	<b>Audited by:</b> J.G.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/06/27	<b>Date:</b> 06/06/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 2
				D2804	
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05-03-11 *[Signature]***D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

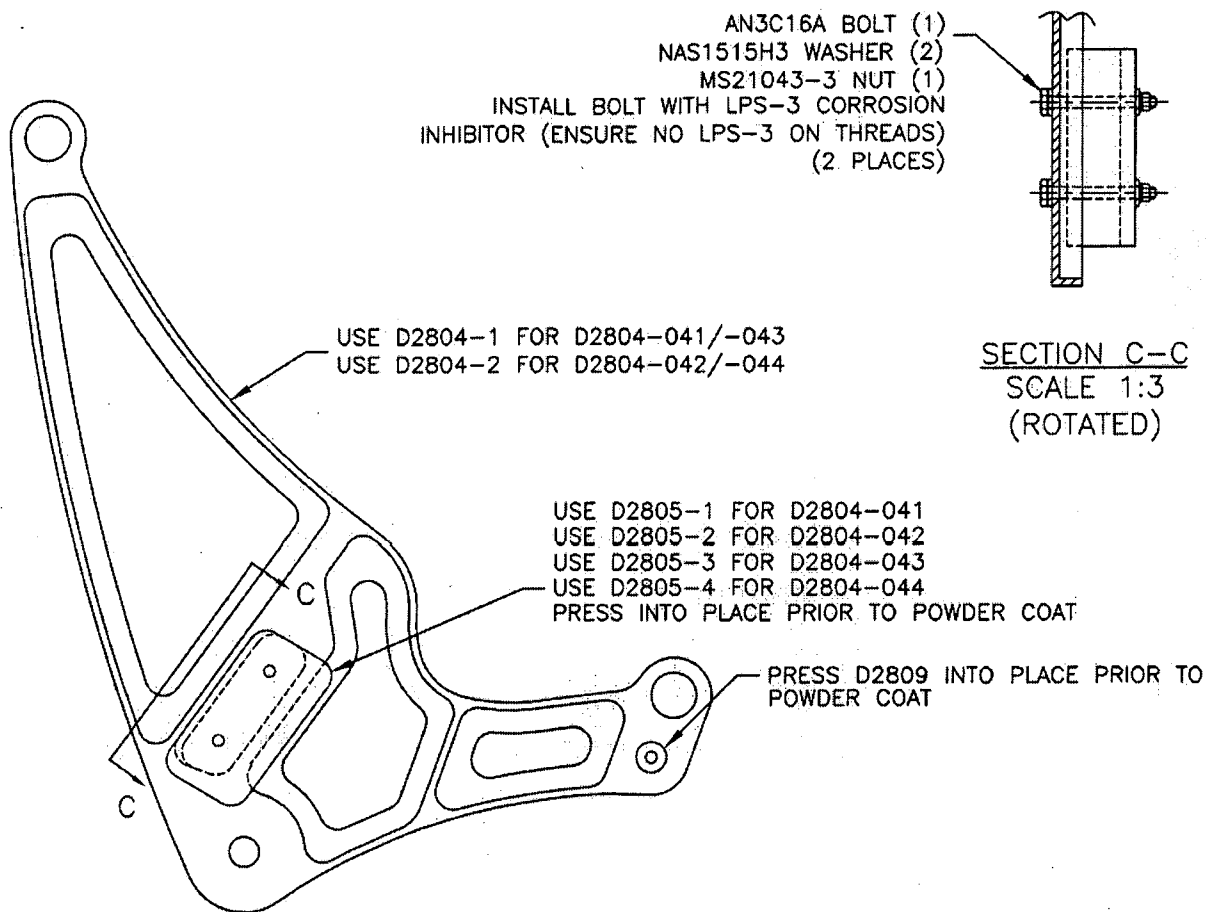
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**DART**

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CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D2804	SHEET 2 OF 2
DATE	TITLE	SCALE	
04.11.22	STA 155 BRACKET	1:3	



**D2804-041/-043 BRACKET ASS'Y (SHOWN)**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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